

Date: Tuesday, 5/23/2006 11:36:44 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CUP
Job Number	: 27228		
Estimate Number	: 12404		
P.O. Number	: NIA	Part Number	: D35031
This Issue	: 5/23/2006 S.O. No. : NIA	Drawing Number	: D3503 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 27198	Material	: NIA
Written By	: <u>SKA</u> COMMENT BELOW	Due Date	: 5/30/2006
Checked & Approved By	: <u>PA 06.05.23 W</u>	Qty:	40 Um: Each
Comment	: Est Rev: A New Issue 06-05-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R100	304 ROUND BAR
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Comment: Qty.: 0.0683 f(s)/Unit Total: 2.7300 f(s)

304 ROUND BAR

(M304R1000)

Batch: B1700706.06.17 BG 40

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA635 & DWG D3503,

FOLIO REV: AADWG REV: A

2-DEBURR AS REQUIRED

BG 06.06.17 40

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 06.06.17 40

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.G 06/06/18 40

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5744806/06/18 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 13 Date: 06/06/20
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 11:36:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 27228

Part Number: D35031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: S 03/06/06

Job Completion



Handwritten: U K-06-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

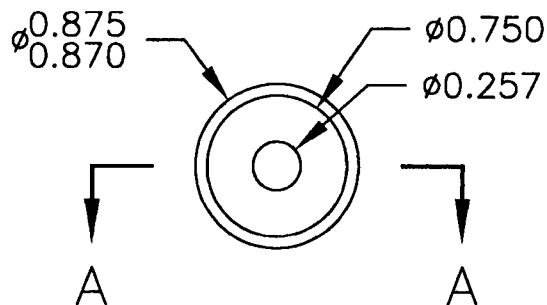
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

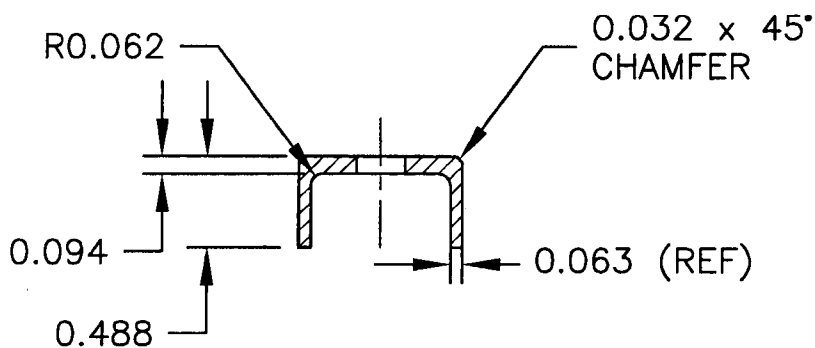


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3503	REV. A SHEET 1 OF 1
DATE 06.04.19		TITLE CUP	SCALE 1:1
A	06.04.19	NEW ISSUE	

RELEASED
06.04.25



D3503-1



SECTION A-A

D3503-1 CUP

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART MATERIAL SPEC M304RX.XXX)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27228

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

FA1 "cup" 02570

Dwg 03503 Rev A

Dwg Dim	Tol	Actual	Accept	Reject
.875/.870	.005	.873	✓	
φ.750	+0.008 -0.001	.751	✓	
φ.257	±0.006	.258	✓	
R.062	±.01	.062	✓	
.032 X .450	±-.01	.040	✓	
.063	±.01	.061	✓	
.488	±-.01	.492	✓	
.094	± ±-.01	.095	✓	

Measured by: TSG 06.06.17

Audited by: J.F. 06/06/17